

Work Order ID 157353***157353***

Page 1

Tuesday, February 21, 2017 12:59:33 PM

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 3/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: FEB 28 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4464	H

100 Weld per dwg A/R Aluminum rod Batch: N30855***100***

Large Fab Memo 0.53
Large Fab 1- Weld D4023-3 cap as per dwg D4464

DAS
43
9-89

MAR 13 2017

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
Quality Control

1x

MAR 13 2017

DAS
24
9-89

112 0.00

112

Small Fab Memo 0.19
Small Fab 1- Wet install baffles to front and back panel using rivet and Proseal as per dwg
A/R Proseal Batch: 136668

1x

DAS
36
9-89
17/03/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

157353

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 3/6/2017 **Start Qty:** 1.00 ***1***

Required Date: 3/27/2017 **Req'd Qty:** 1.00 ***1***

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

114

0.00

17-03-15

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Re work ☐ Scrap ☐ Use as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. COOR. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R Aluminum rod Batch: <u>4130855</u>	0.00							
120									
Large Fab	Memo	0.40							
Large Fab	1- Weld D4001-1 and D4000-5 onto D4463-1 Top								
	2- Weld D3999-041/-043 doubler, ensure doubler and angle holes line-up for D4000-047								
	Transfer drill and c'sink D4975-1 bracket to bottom bracket, wet install as per dwg								
	Proseal 890B Batch: <u>136665</u>								
	3- Weld D4000-043 and D4000-045 on tank as per dwg.								
	4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 and wet install with rivets as per dwg. ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG***								
	Proseal 890B Batch: <u>136665</u>								
	5- Install hinge wet with proseal as per dwg								
	A/R Proseal 890B Batch: <u>136665</u>								
	6-Weld D4463-7 fwd end								
	PURGE INSIDE OF TANK								
	7-Weld top D4463-1 using DT9811 and DT9810								

DAS 43 9-89 MAR 21 2017

DAS 36 9-89 1.7/03/17

DAS 43 9-89 1x MAR 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	PURGE INSIDE OF TANK								
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg D4464*** DWA PTO 9-89	0.00 0.00				①	17-03-27		DAS 9 9-89
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				①	17-03-27		DAS 9 9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>157353</u> Part No. <u>D4464-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. COOR. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval DAS 9 9-89					
Description Work Order Deviation Move memo to seg 180 (pressure test is done after assembly.)				Disposition 				Completed By DAS 10 9-89				
				Lead hand / Supervisor Approval Verification								
				QC / QA Coordinator Approval								
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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OTHER : _____												

Work Order ID 157353

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Item ID: D4464-041 Accept ***N1900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 3/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/27/2017 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
143 *143* Outsource2 Outsource process - NDT	Memo ISSUE P/O : <u>35752</u> LPI INSPECTION C OF C IS REQUIRED	0.00 30.00				<u>1</u>		MAR 28 2017	DAS 13 9-89
145 *145* Packaging Packaging	Memo	0.00							<u>IX SPI7-03-28</u>
147 *147* QC Quality Control	Memo	0.00				<u>1</u>			DAS 38 9-89 MAR 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

157353

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N900040100

Setup Start *NS1*

Stop *NS2*

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Required Date: 3/27/2017 **Req'd Qty:** 1.00 ***1***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.20

Hand Finishing

1- Alodine on tank. No alodine inside

(X1) ~~0~~ _____ 207/03/29
BEB

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

4 _____ 07/03/27

164

0.00

164

Small Fab

Memo

0.25

Small Fab

1- Brush Proseal 890A on all internal sheet metal folds

Proseal 8990A Batch: 136605

2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B

A/R Proseal 890B Batch:

IX _____ 17/03/2019

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 3/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

EB
17-03-31

190

0.00

190

Small Fab

Memo

0.24

Small Fab

1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg

2- Abrade surface with red scotch brite and install cushion using contact cement

A/R Contact Cement Batch: 136812
1300LIX
DAS 36 9-89
17/03/31

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

DAS 38 9-89
MAR 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Page 1

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG
REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG
REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD
VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD
VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD
VERF:JLM IPP REV:I 15.06-17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-6

Purchased

No

190

Each

2,164.000

8

8

MS20470AD4-6

Rivet, Universal Head

**

17/03/21

DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

1566

m136787

1566

GA

376

m133077

376

ST310

222

m134852

222

D3999-7

Manufactured

No

120

Each

6.0000

1

1

D3999-7

Corner

**

B 154230 → 1x43

DAS
43
9-89

MAR 25 2017

Location

Loc Qty

Loc Code

WA003

6

108621

3

154230

2

155307

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4000-1	Manufactured	No	120	Each	8.0000	1	1	
D4000-1								
Fuel Supply Fitting								

DAS 36 9-89
17/03/21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	8	
137221	3	
153006	5	

D4000-5	Manufactured	No	120	Each	7.0000	1	1	
D4000-5								
Fuel Tank Vent Fitting								

DAS 43 9-89
**8107388 → 1x MAR 25 2017

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	7	
107388	3	
152339	4	

D4000-9	Manufactured	No	120	Each	39.0000	3	3	
D4000-9								
Grommet								

DAS 36 9-89
17/03/21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	39	
137219	9	
152269	30	

D4000-045	Manufactured	No	120	Each	4.0000	1	1	
D4000-045								
Fuel Pickup Fitting Assembly								

DAS 36 9-89
17/03/21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	4	
151966	4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4008-11 Manufactured No

120 Each 4.0000 1 1

D4008-11

Hinge Half

**

DAS
36
9-89

17/03/21

Location

Loc Qty

Loc Code

GA

4

129867

2

152992

2

B154386(1)

D4057-1 Manufactured No

120 Each 70.0000 3 3

D4057-1

Retaining Ring

**

DAS
36
9-89

17/03/21

Location

Loc Qty

Loc Code

GA

20

107269

20

WA003

50

156450

50

3

D4125-1 Manufactured No

120 Each 1.0000 1 1

D4125-1

Fwd Sediment Bowl

**

DAS
43
9-89

B156449 → 1x

MAR 25 2017

Location

Loc Qty

Loc Code

WA003

1

144614

1

D4125-3 Manufactured No

120 Each 1.0000 1 1

D4125-3

Aft Sediment Bowl

**

DAS
43
9-89

B156459 → 1x

MAR 25 2017

Location

Loc Qty

Loc Code

WA003

1

144763

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4404-5

Manufactured No

120 Each

10.0000

2 2

D4404-5

Cushion, Fwd

**

17/03/31

DAS
36
9-89

Location

Loc Qty

Loc Code

st510

4

154416

4

ST516

6

151103

2

156461

4

2

D4462-1

Manufactured No

112 Each

3.0000

1 1

D4462-1

Baffle

**

B156466 → 1x

DAS
43
9-89

MAR 13 2017

Location

Loc Qty

Loc Code

WA003

3

145952

1

154543

2

D4462-3

Manufactured No

112 Each

2.0000

1 1

D4462-3

Baffle

**

B156493 → 1x

DAS
43
9-89

MAR 13 2017

Location

Loc Qty

Loc Code

WA003

2

154385

2

D4463-041

Manufactured No

120 Each

3.0000

1 1

D4463-041

Tank Top Assembly

**

B154415 → 1x

DAS
43
9-89

MAR 25 2017

Location

Loc Qty

Loc Code

WA003

3

152188

1

154415

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4463-3

Manufactured No

120 Each

4.0000

1 1

DAS

43

9-89

MAR 25 201

✓ *D4463-3*

Tank Aft End

** B157410 → 1x

Location

Loc Qty

Loc Code

WA003

4

154384

4

D4463-5

Manufactured No

120 Each

9.0000

1 1

DAS

43

9-89

MAR 25 201

✓ *D4463-5*

Tank Upper Cut Out

** B106751 → 1x

Location

Loc Qty

Loc Code

WA003

9

106751

9

D4968-1

Manufactured No

190 Each

4.0000

1 1

**

17/03/31 DAS 36 9-89

D4968-1

Side Cushion

Location

Loc Qty

Loc Code

ST400

4

151546

4

D4463-7

Manufactured No

120 Each

1.0000

1 1

DAS

43

9-89

MAR 25 201

✓ *D4463-7*

Tank Fwd End

** B154418 → 1x

Location

Loc Qty

Loc Code

WA003

1

150840

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : 9AM		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER :							

Picklist Print

Tuesday, February 21, 2017 12:59:38 PM

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4023-3

Manufactured No

190 Each

10.0000 1 1

✓ *D4023-3*

Cap And Flange

**B156726 → 1x DAS 43 MAR 13 2017 9-89

Location

Loc Qty

Loc Code

WA003

10

122537

1

132479

2

152210

1

152599

1

154435

3

156726

2

D4463-9

Manufactured No

112 Each

1.0000 1 1

✓ *D4463-9*

Tank Back

**B157010 → 1x DAS 43 MAR 13 2017 9-89

Location

Loc Qty

Loc Code

WA003

1

150841

1

D4025-5

Manufactured No

190 Each

9.0000 1 1

D4025-5

Fuel Quantity Sender

** 17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST240

9

143838

3

147065

4

154427

2

D4463-11

Manufactured No

112 Each

4.0000 1 1

✓ *D4463-11*

Tank Front

**B154387 → 1x DAS 43 MAR 13 2017 9-89

Location

Loc Qty

Loc Code

WA003

4

146056

1

154387

3

Tuesday, February 21, 2017 12:59:38 PM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 7

Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4577-1

Manufactured No

190 Each

6.0000

1

1

D4577-1

Rear Access Panel

**

17/03/29 DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

6

146093

4

152343

2

Manufactured No

190 Each

8.0000

1

1

D3997-29

D3997-29

Placard

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST069

8

127111

2

152611

6

11/8/2017

Manufactured No

190 Each

16.0000

2

2

D3997-5

D3997-5

Placard

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST069

16

156464

6

2/14/2017

150868

4

9/15/2017

154447

6

12/23/2017

Manufactured No

190 Each

7.0000

1

1

D3997-17

D3997-17

Placard

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST069

7

129866

1

152258

6

11/8/2017

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Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D3997-43

Manufactured No

190

Each

7.0000

1

1

D3997-43

Placard

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST069

7

127112

1

152179

6

11/8/2017

DAS 36 9-89

157334 1x

NAS1149D0332J

Purchased No

190

Each

1,306.000

13

NAS1149D0332.J

Washer

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

FP001

20

m134848

20

GA

98

m134848

98

ST260a

600

m136643

600

ST264

588

m136015

588

12

D4463-13

Manufactured No

190

Each

2.0000

1

1

D4463-13

Tank Bottom

**

DAS 43 9-89

MAR 25 2017

B 157399 → 1x

Location

Loc Qty

Loc Code

WA003

2

154417

2

98-6
98
SVQ

NAS1149D0316J

M 134502

1 x

17/03/31 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4975-1

Manufactured No

190 Each

5.0000 1 1

D4975-1

Bracket

**

17/03/21 DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

5

145518

3

154509

2

D4008-041

Manufactured No

190 Each

11.0000 1 1

D4008-041

Fuel Filler Splash Guard Assembly

**

17/03/31 DAS 36 9-89

Location

Loc Qty

Loc Code

ST143

2

153054

2

ST243

9

137305

1

154405

8

AN3-5A

Purchased No

169 Each

238.0000 24 24

AN3-5A

Bolt

**

17/03/29 DAS 36 9-89

Location

Loc Qty

Loc Code

ST350

238

m136182

238

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

190

Each

2,164.000

4

4

MS21042L3

Nut

**

17/03/31

DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

318

m134360

108

m135135

18

M136665

192

OVER007

300

m134360

0

M136665

300

ST303

505

M136406

5

M136554

500

ST3030

941

M136838

941

4

AN3H5A

Purchased

No

190

Each

42.0000

5

5

AN3H5A

Bolt

**

17/03/31

DAS
36
9-89

Location

Loc Qty

Loc Code

ST350

42

m134852

17

m136406

25

5

D3997-11

Manufactured

No

190

Each

8.0000

1

1

D3997-11

Placard

**

17/03/31

DAS
36
9-89

Location

Loc Qty

Loc Code

ST069

8

127110

2

152610

6

11/8/2017

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-7A
Bolt

Purchased No 190 Each 89.0000 4 4

**

17/03/31 DAS 36 9-89

Location Loc Qty Loc Code

ST349 89
m135058 89

4

D4577-3
D4577-3
Middle Access Panel

Manufactured No 190 Each 5.0000 1 1

**

17/03/29 DAS 36 9-89

Location Loc Qty Loc Code

WA003 5
146801 4
152207 1

156440 (10)

D4062-041
Tank Support Assembly

Manufactured No 190 Each 10.0000 1 1

**

17/03/31 DAS 36 9-89

Location Loc Qty Loc Code

WA003 10
145585 6
154517 4

1

MS20426AD4-4
MS20426AD4-4
Rivet

Purchased No 190 Each 3,126.000 4 4

**

17/03/21 DAS 36 9-89

Location Loc Qty Loc Code

GA 1399
125445 1399
ST312 1727
m132536 1727

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Work Order ID: 157353

157353

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/6/2017

Required Date: 3/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4577-041

Manufactured No

190 Each 5.0000 1 1

D4577-041

Fwd Access Panel Assembly

**

17/03/29
DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

5

146803

4

154524

1

MS20470AD4-4

Purchased No

190 Each 3,826.070 165 165

MS20470AD4-4

Rivet, Universal Head

**

17/03/15
DAS 36 9-89

Location

Loc Qty

Loc Code

CCK004

2069.001

M135133

0.001

M136851

2069

GA

1377.069

M134294

101

M134848

378

M135133

0.069

M135536

67

M136042

93

M136301

738

ST310

380

M132803

380

NAS1149D0363J

Purchased No

190 Each 1,027.000 24 24

NAS1149D0363.J

Washer

**

17/03/29
DAS 36 9-89

Location

Loc Qty

Loc Code

GA

197

m134055

197

ST263

830

m136318

23

m136781

807

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	1	D4125-1	FWD SEDIMENT BOWL
18	1	D4125-3	AFT SEDIMENT BOWL
19	2	D4404-5	CUSHION, FWD
20	1	D4462-1	BAFFLE
21	1	D4462-3	BAFFLE
22	1	D4463-041	TOP TANK ASSEMBLY
23	1	D4463-3	TANK AFT END
24	1	D4463-5	TANK UPPER CUT OUT
25	1	D4463-7	TANK FORWARD END
26	1	D4463-9	TANK BACK
27	1	D4463-11	TANK FRONT
28	1	D4463-13	TANK BOTTOM
29	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
30	1	D4577-1	REAR ACCESS PANEL
31	1	D4577-3	MIDDLE ACCESS PANEL
32	1	D4968-1	CUSHION, SIDE
33	1	D4975-1	ANGLE BRACKET
34	24	AN3-5A	BOLT
35	5	AN3H5A	BOLT
36	4	AN3-7A	BOLT
37	4	MS20426AD4-4	RIVET, CSK
38	165	MS20470AD4-4	RIVET, PANHEAD
39	8	MS20470AD4-6	RIVET, PANHEAD
40	4	MS21042L3	NUT
41	13	NAS1149D0332J	WASHER
42	24	NAS1149D0363J	WASHER

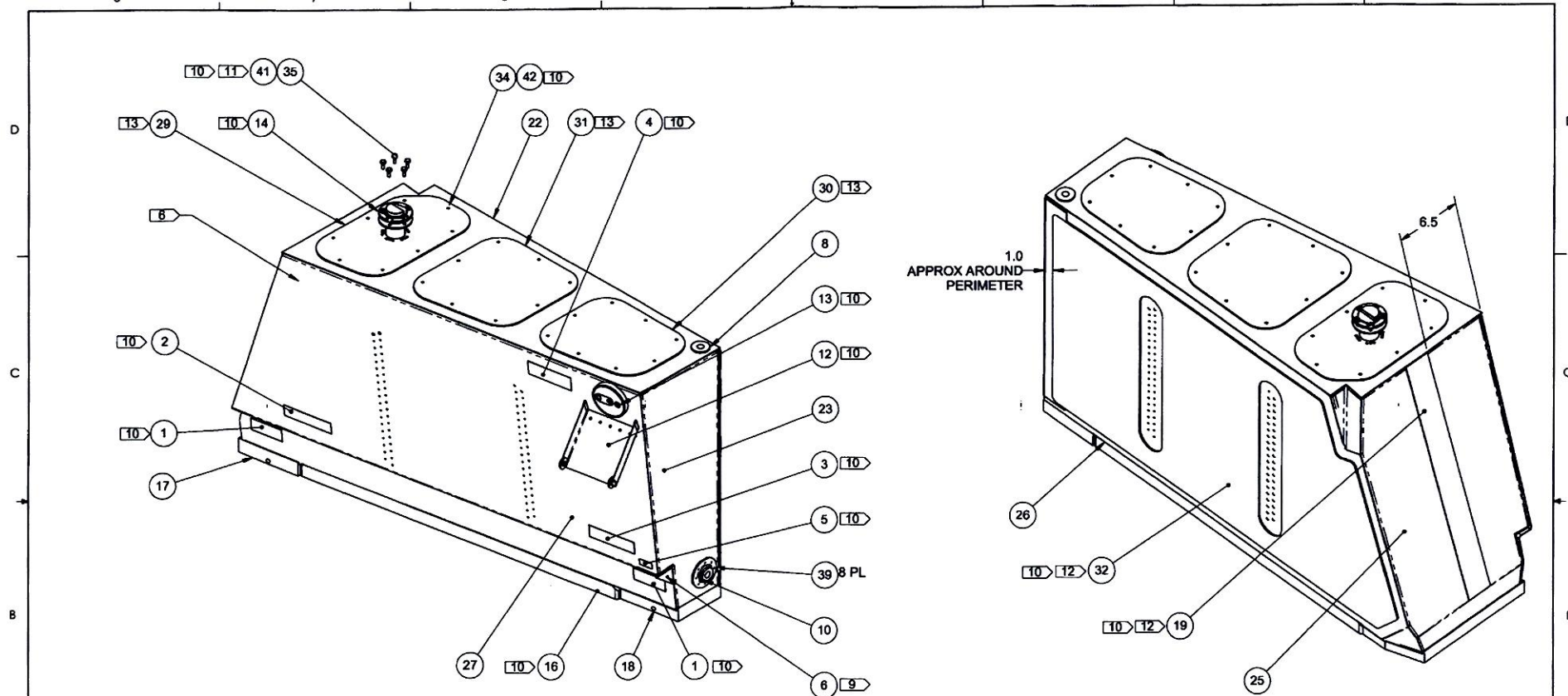
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NO. 157353
FEB 28 2017

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2015-06-18
ECN 15-583

H	REPLACED NOTE 8 (SHT 2), ADDED NOTE 14 (SHT 2), ADDED AUXILIARY VIEW (SHT 3), ADDED NOTE 15 (SHT 4), REPLACED NOTE 13 (SHT 5), SHT 4 WAS SHT 3, SHT 5 WAS SHT 4, REMOVED D4124-1 TABS & AN3-6A BOLTS, CHEMICAL CONVERSION COAT NOW AFTER WELDING (SHT 5), ADD AN3-7A BOLTS	CC	15.02.06
G	FINISH "FLAT GREY" WAS "GREY" (SHT 2); PICTORIAL UPDATE FOR D4000-1 & D4462-1	AP	14.12.05
F	AN3-5A WAS AN3C4A QTY. 24 (ZN D6-2) AN3H5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-4 WAS MS20426AD4-4 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.06.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/9/11 AND D4462-1/3. D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/13 REV. C PARTS, ZN B8-2. UPDATED -041 WITH RE-DESIGNED D4577-041/3/5 PARTS, ZN C8-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/1/5 ACCESS PANELS, ZN C8-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
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APPROVED

8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 39.52 lbs
- 8) LPI AND PRESSURE TEST PER DART QSI 038 6.3
- 9) MASK PRIOR TO FINISH
- 10) INSTALL AFTER FINISH
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

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8 7 6 5 4 3 2 1

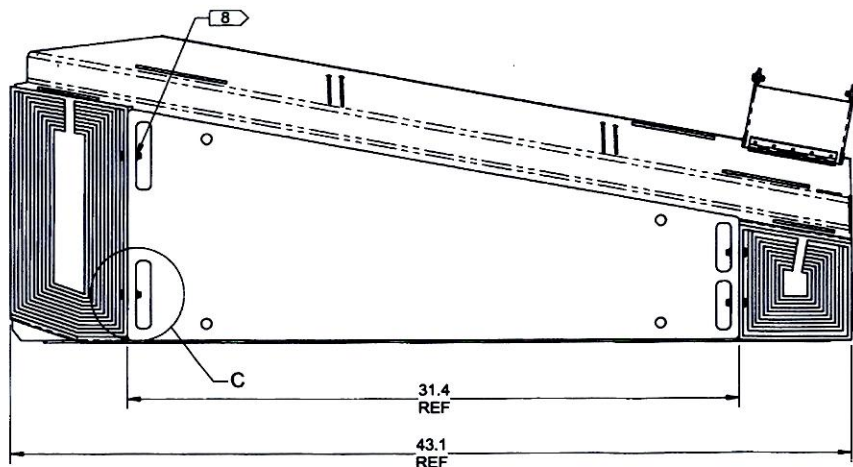
8 7 6 5 4 3 2 1

D

C

B

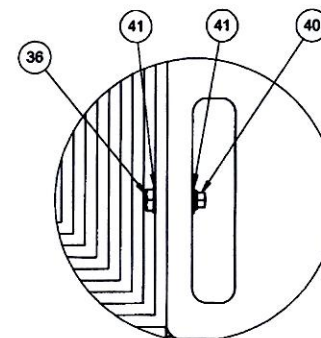
A



D4464-041 FUEL TANK ASSEMBLY
AUXILIARY VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRANSFER DRILL HOLES FROM D4125-1/3 SEDIMENT BOWLS TO D4062-041 TANK SUPPORT ASSEMBLY



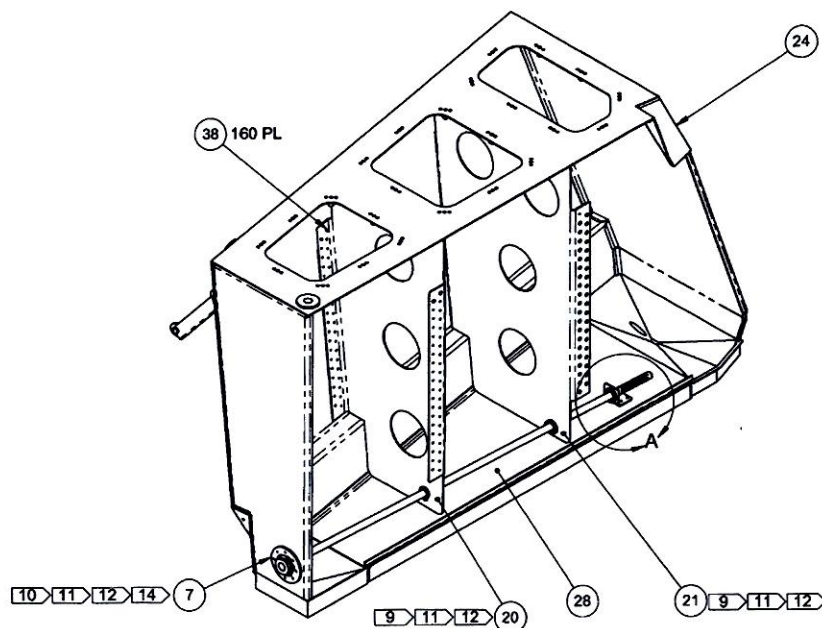
DETAIL C
SCALE 3X

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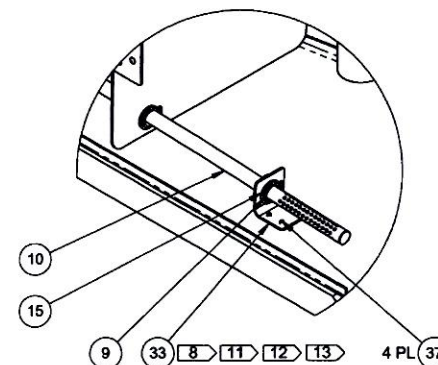
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8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY 
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

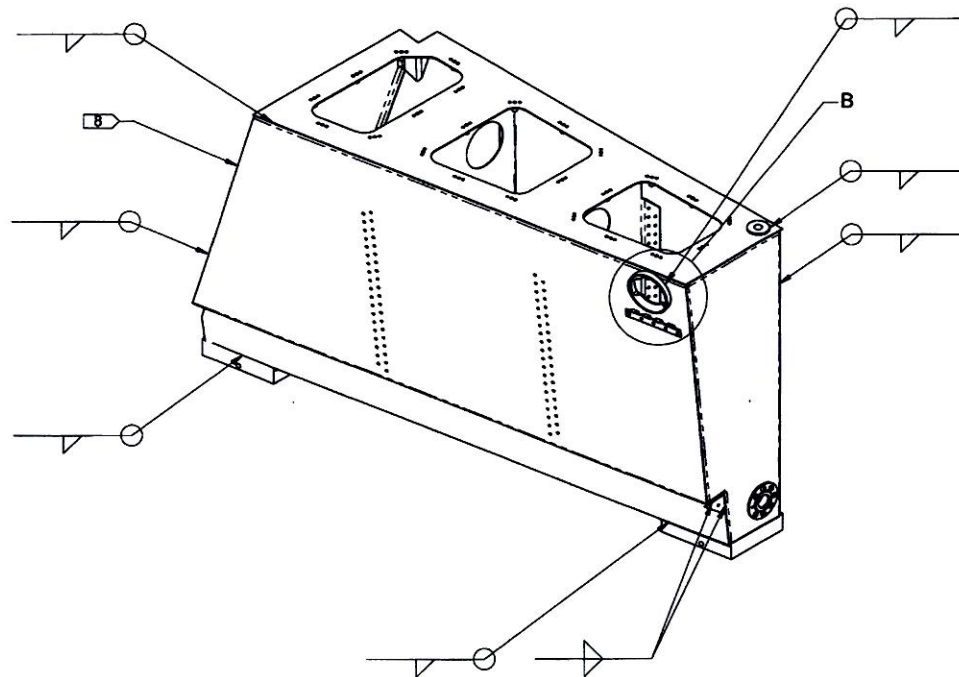
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\varnothing 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\varnothing 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS
- 15) BRUSH PROSEAL 890A ON ALL INTERNAL SHEET METAL FOLDS

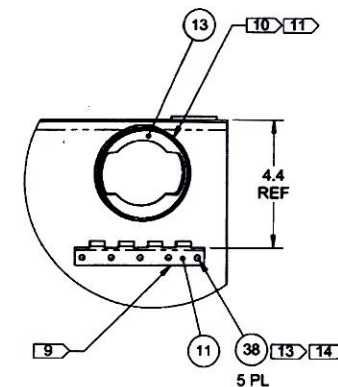
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D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 14) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

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2015-06-16

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**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO31540	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO35752
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 1 FUEL TANK AND 6 SLEEVES AS PER PO35752

1 FUEL TANK ASSY, ITEM ID# D4464-041, WORK ORDER ID# 157353

6 SLEEVES, ITEM ID# D3689-1, WORK ORDER ID# 156909

P17-03-28

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						MAR 28 2017	
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, EMU. MPO15896, DEV. MPO11715, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAS
38
9-89

MAR 29 2017

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		MAR 28 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35752**

Purchase Order Date 3/27/2017 2:28:45 PM

PO Print Date 3/28/2017

Page Number 2 of 2

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

905-678-5636

Ship To Contact

Ship To Phone

Ship Via:

Delivered

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$0.00

3

157353

D4464-041 AUX TANK

3/28/2017

Yes

3/28/2017

1.00

\$0.00

\$0.00

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

PO Total: \$0.00

SPT-03-28

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

2

Change Date:

3/28/2017